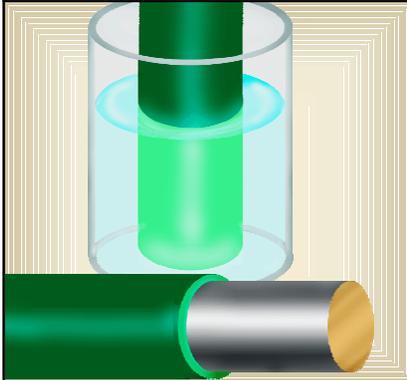


**WIRE PREPARATION
CHEMICAL STRIPPING**

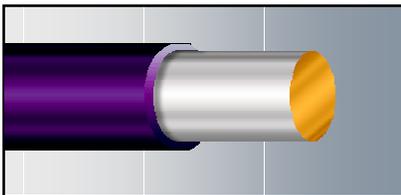


CHEMICAL STRIPPING

Chemical stripping of organic insulation from solid conductors is an alternative to mechanical stripping, especially on small gauge (≤ 28 ga.) conductors. The process is an efficient method to use for complete removal of the insulation, resulting in an exposed, clean, solderable conductor surface.

Chemical stripper agents range in degrees of aggressiveness, towards both the insulation material and the conductor metallization.

See Section 1.01 "Wire Preparation, General Requirements", for common accept / reject criteria.



PREFERRED

The insulation jacket has been neatly removed, with no damage to the conductor or insulation. No wicking of stripper or cleaner agents under the insulation jacket is evident.

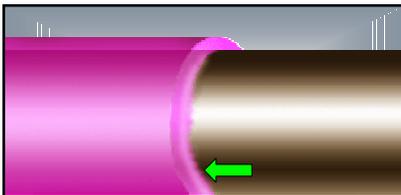
Note: Chemical stripping is suitable for solid conductors only.



**UNACCEPTABLE
INAPPROPRIATE CONDUCTOR TYPES**

Chemical stripping of other than solid, single-conductor wire (i.e.: coaxial cable, flat cable, multi-conductor cable, ribbon cable, shielded, stranded, etc.) is prohibited.

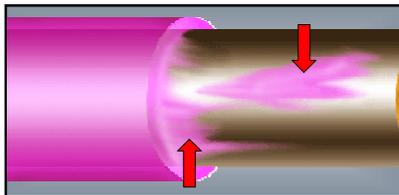
[Best Workmanship Practice](#)



**ACCEPTABLE
EDGE FLASH / SMEARING**

Edge flash shall not exceed one-quarter insulated wire diameter ($\frac{1}{4} d$). Edge flash and smearing (as depicted) is considered normal, and should not contaminate or interfere with a crimped or soldered termination.

[NASA-STD-8739.4 \[10.1.6 \]](#)



**UNACCEPTABLE
EDGE FLASH / SMEARING**

The edge flash is in excess of one-quarter insulated wire diameter ($\frac{1}{4} d$), and the stripped section exhibits smearing (melted insulation / film) which is considered a contaminant.

[NASA-STD-8739.4 \[10.1.6 \]](#)

NASA WORKMANSHIP STANDARDS



NATIONAL AERONAUTICS AND SPACE ADMINISTRATION
JOHNSON SPACE CENTER
HOUSTON, TEXAS USA 77058

Released:
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Revision:
A

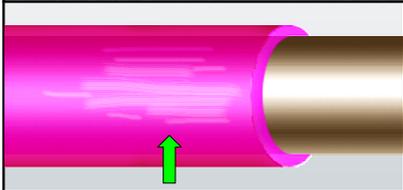
Revision Date:
07.03.2002

Book:
1

Section:
1.04

Page:
1

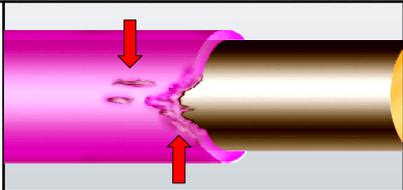
**WIRE PREPARATION
CHEMICAL STRIPPING (cont.)**



**ACCEPTABLE
SCUFFED INSULATION / JACKET**

Slight scuffing (a dull or rubbed appearance) of the insulation surface finish is acceptable, provided no other damage is evident.

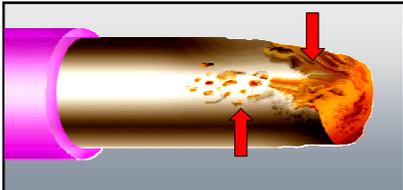
[NASA-STD-8739.3 \[7.2.2 \]](#)
[NASA-STD-8739.4 \[10.1.2 \]](#)



**UNACCEPTABLE
DAMAGED INSULATION / JACKET**

The conductor insulation and/or cable jacket shall not exhibit any damage, such as nicks, cuts, or charring. Conductors / jackets exhibiting damage (other than minor scuffing) shall not be used.

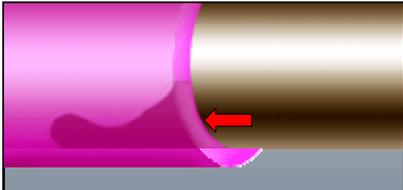
[NASA-STD-8739.3 \[13.6.2.a.1 \]](#)
[NASA-STD-8739.4 \[19.6.2.a.2 \]](#)



**UNACCEPTABLE
BURNS / CORROSION / PITTING**

Burns, corrosion, and pitting are typically caused by the use of an extremely aggressive or chemically incompatible stripping agent, or excessive exposure.

[NASA-STD-8739.3 \[13.6.2.a.7 \]](#)
[NASA-STD-8739.4 \[19.6.2.a.2 \]](#)



**UNACCEPTABLE
WICKING**

Wicking of chemical stripping and/or cleaning agents under the insulation jacket is a long-term reliability concern.

[NASA-STD-8739.3 \[13.6.2.a.9 \]](#)

| | | | | |
|---|--|----------------------|---------------|---------------------------|
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